

Date: Thursday, 10/25/2007 10:05:48 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 35360	
Estimate Number : 12524	
P.O. Number : <u>N/A</u>	Part Number : D35341
This Issue : 10/25/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3534 REV A
Prsht Rev. : NC	Project Number : <u>N/A</u>
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34785	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 11/8/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>8</u> Um: Each
Comment : Est Rev: A New Issue 07-09-24 EC verified by DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.2048 sf(s)/Unit Total : 0.8190 sf(s)
 2024-T3 .050 sheet
 Batch: 105646 IB 07-10-30

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3534
 Dwg Rev: A
 Prog Rev: A

IB 07-10-30(8)

2-Deburr if necessary IB 07-10-30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

counter
IB 07-10-30 (x8)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

FL 07/11/01 (8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 21/11/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:05:48 AM
User: Kira Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 35360

Part Number: D35341

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



⑧

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-11-01

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51108

Ⓢ

07/11/02 NS

Ⓢ

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Ⓢ

Comment: FINAL INSPECTION/W/O RELEASE

07/11/02

Job Completion



U 07-11-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

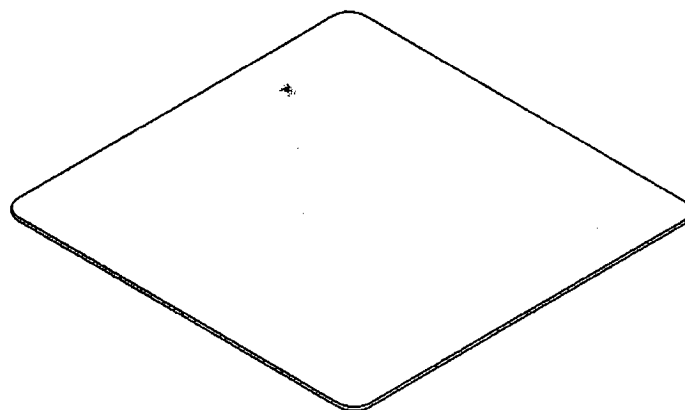
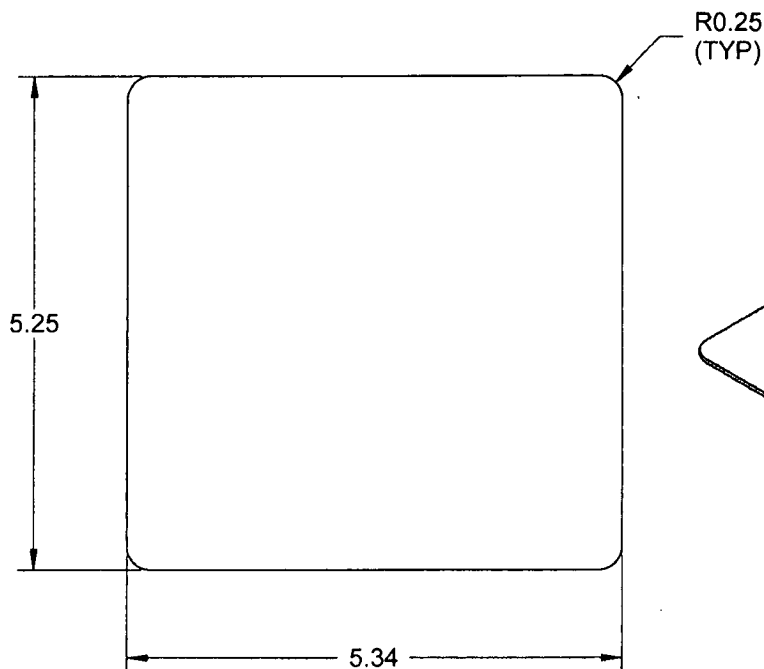
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3534	REV. A SHEET 1 OF 1
DATE 07.01.10		TITLE DOUBLER	SCALE 1:2
REV A	DATE 07.01.10	DESCRIPTION NEW ISSUE	

RELEASED
07.08.03 *[Signature]*



D3534-1 DOUBLER

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3534-1" USING FINE POINT PERMANENT INK MARKER

SHOP COPY
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NO. **35360**

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